

Tuesday, February 15, 2011 11:46:07 AM

Item ID: D4018-041

Accept

Setup Start

Stop

Start Date: 2/16/2011 **Start Qty:** 1.00

Required Date: 2/23/2011 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Run Start

Approvals: Process Plan: MF

Date: 11-02-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Operation	Description
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100	...

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

Accept
Qty

Reject
QtyReject
Number

Insp. Stamp

Draw Nbr

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: M114649 0.00

0.00

100% of the respondents were female, and 90% were aged 18 years or older. The majority of respondents were employed (70%), and 60% were married. The majority of respondents were from the United States (70%), and 60% were from the Midwest region. The majority of respondents were from the United States (70%), and 60% were from the Midwest region. The majority of respondents were from the United States (70%), and 60% were from the Midwest region.

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

[illegible]

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 66473

Tuesday, February 15, 2011 11:46:07 AM

Page 2

Item ID: D4018-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Lid Assembly (350)

Start Date: 2/16/2011 Start Qty: 1.00

Required Date: 2/23/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: 10:00

Oven Temperature: 320 °F

Finish Time: 10:30

140

Wing Walk as per dwg QSI005 4.4 Batch M116402

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- install label

(IX) m-f 11/03/02

1 4 11/03/02

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Picklist Print

Tuesday, February 15, 2011 11:45:59 AM

Page 1

Work Order ID: 66473

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 2/16/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4018-1 Rib		Manufactured	No			100	Each	2.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
				65915				2					
✓ D4018-3 Rib		Manufactured	No			100	Each	2.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
				65918				2					
✓ D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	8.0000	3	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				8					
				64845				2					
				66286				6					
✓ D4018-5 Rib		Manufactured	No			100	Each	13.0000	6	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				13					
				65428				13					

B66557 (2x) 11.02.23

11.02.23

2x 3 11.02.23

3x 6 B66289 (6x) 11.02.23

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Tuesday, February 15, 2011 11:45:59 AM

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 2/16/2011**Required Date:** 2/23/2011**Start Qty: 1.00**

Required Qty: 1.00

Part Number	Description	Material	Quantity	Unit	Price	Quantity	Unit	Price	Quantity	Unit	Price
✓ D4035-041	Lid Rib Assembly, Fwd (350 Basket)	Manufactured	No	100	Each	0.0000	1	1	1	1	1
✓ D4035-043	Lid Rib Assembly, Aft (350 Basket)	Manufactured	No	100	Each	0.0000	1	1	1	1	1
✓ D2581	Mounting Bracket	Manufactured	No	100	Each	30.0000	2	2	2	2	2

Location

Loc Qty

Loc Code

WA





30

64112

7

65950

23

Part Number	Description	Material	Quantity	Unit	Price	Value	Signature	Date
D4020-7	Manufactured	No	100	Each	0.0000	1		11.02.23
Mesh (350 Basket Short, Lid)								11.02.23
D4021-3	Manufactured	No	100	Each	8.0000	1		11.02.23
Data Plate								11.02.23

Location

Loc Qty**Loc Code**

WA

8

56050



1

65916

3

65922

4

D2728-3	Manufactured	No	140	Each	0.0000	1	1
							(v1) 24 11/03/02
Dart Logo label							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

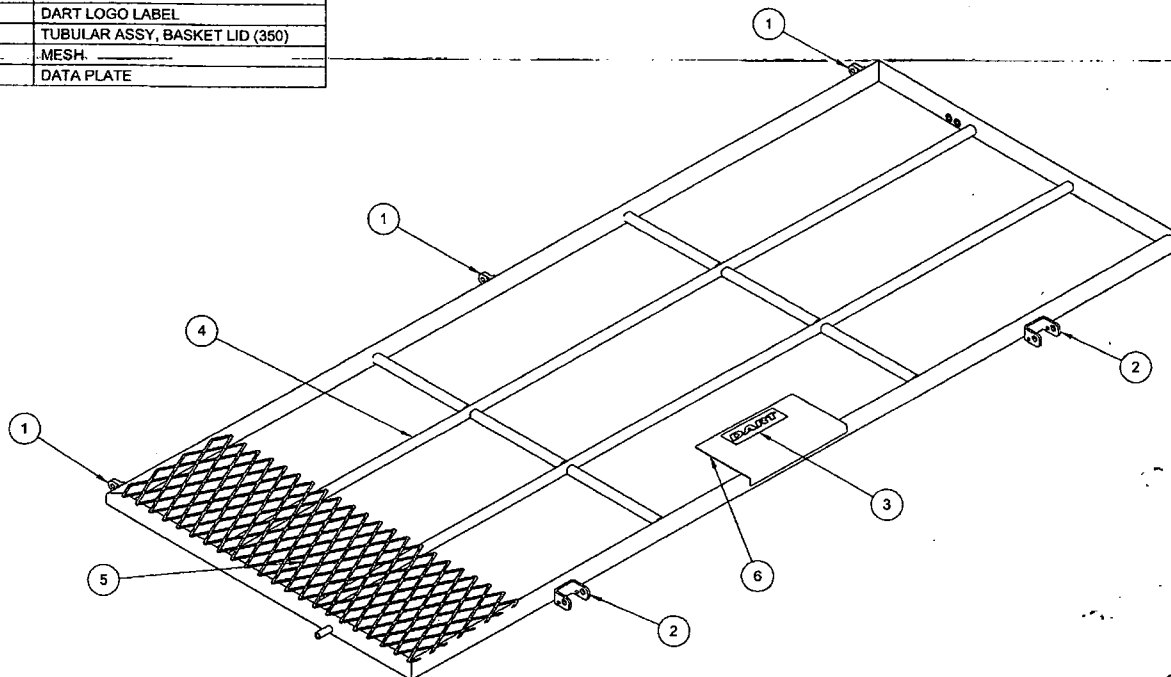
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4018-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. C
CHECKED	SC	D4018	SHEET 1 OF 4
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	SHORT BASKET LID ASSY (350)	NTS
DE APPR.	SC	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

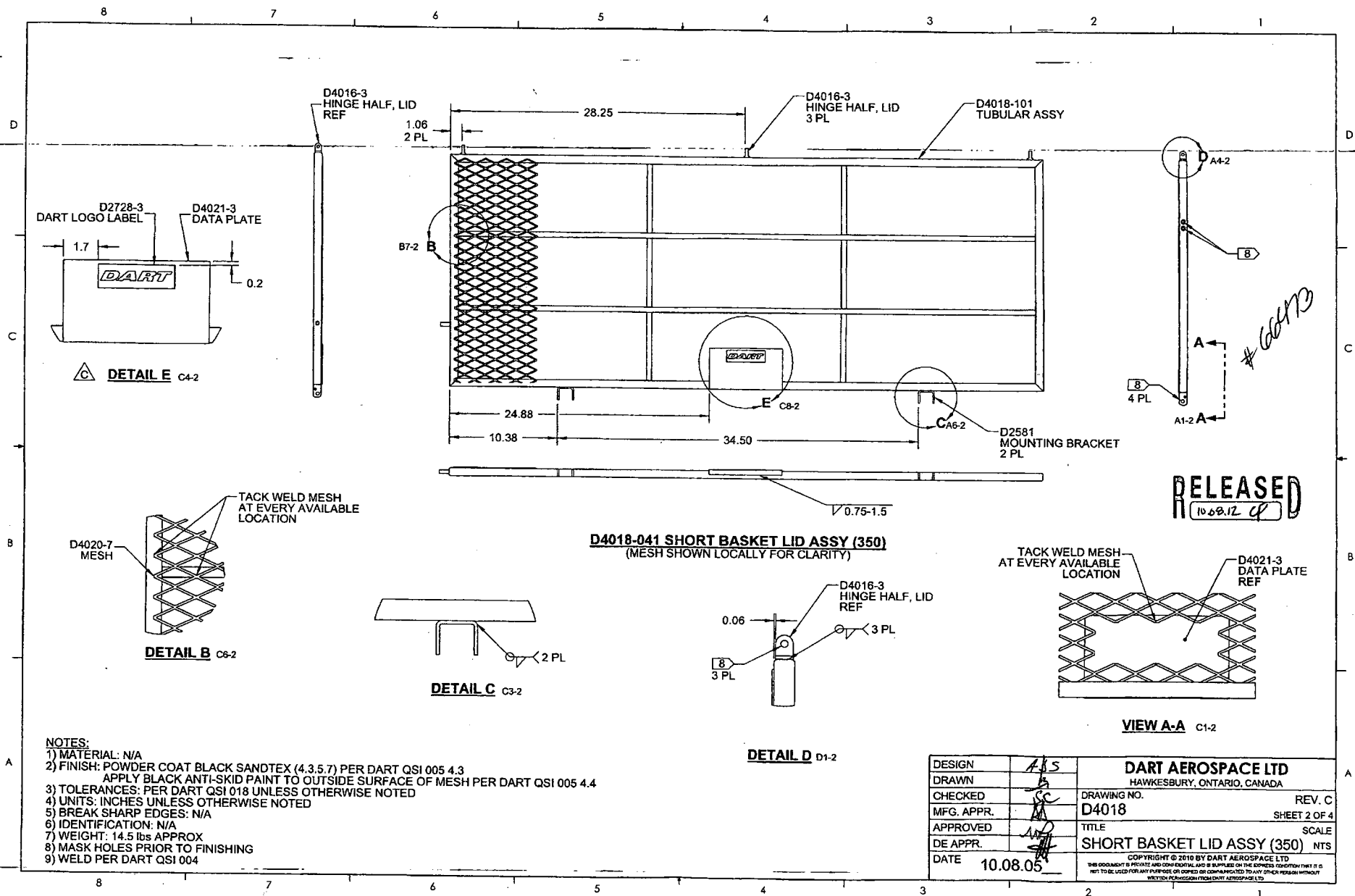
W/O:		WORK ORDER CHANGES					
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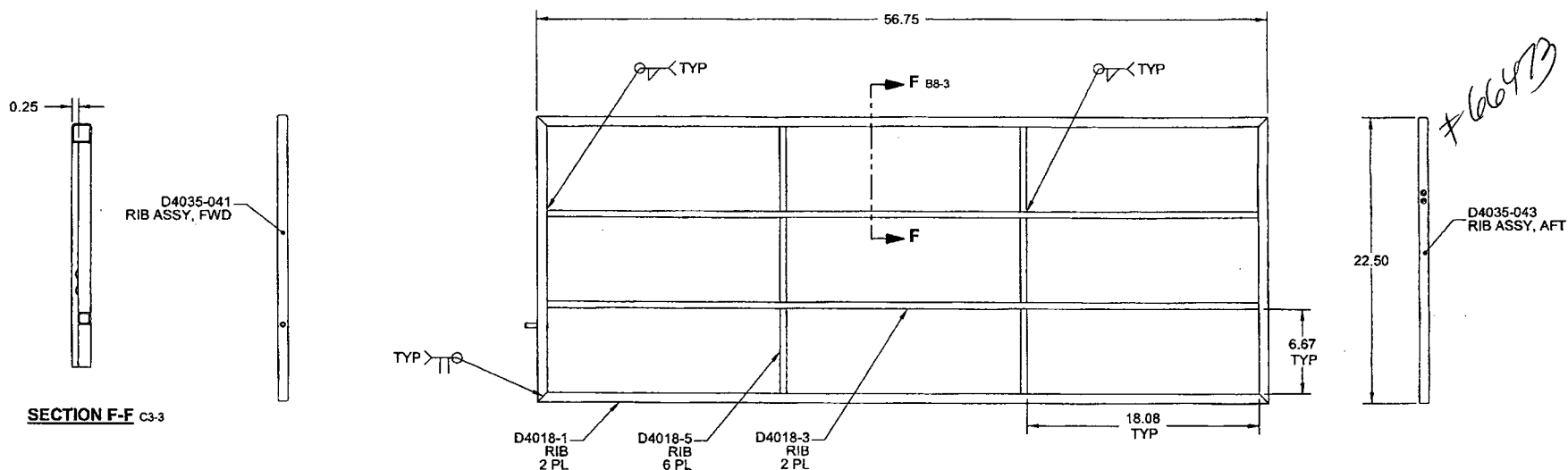
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D4018	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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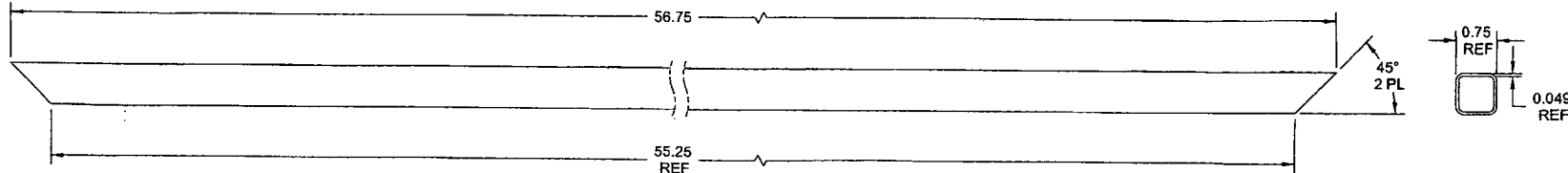
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8 7 6 5 4 3 2 1

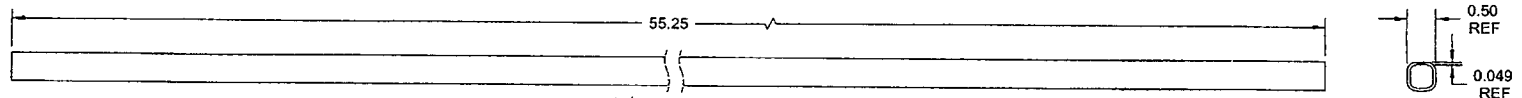
D

D



D4018-1 RIB

#666473



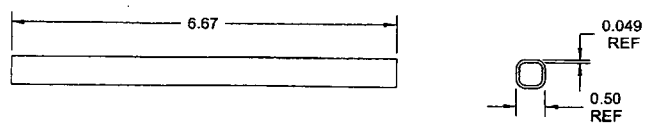
D4018-3 RIB

C

C

B

B



D4018-5 RIB

NOTES:

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.05

DESIGN	<i>ALS</i>	DART AEROSPACE LTD	
DRAWN	<i>ISC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ISC</i>	DRAWING NO. D4018	REV. C
MFG. APPR.	<i>ISC</i>	SHEET 4 OF 4	
APPROVED	<i>ISC</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1

A

A

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